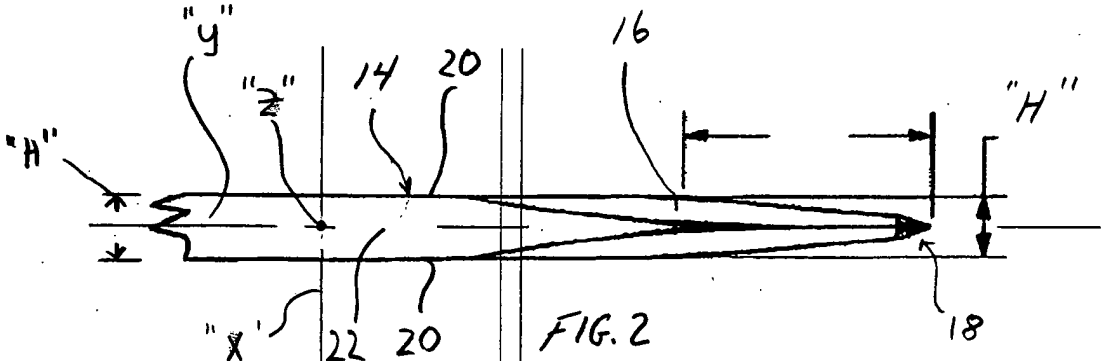


FIG. 2

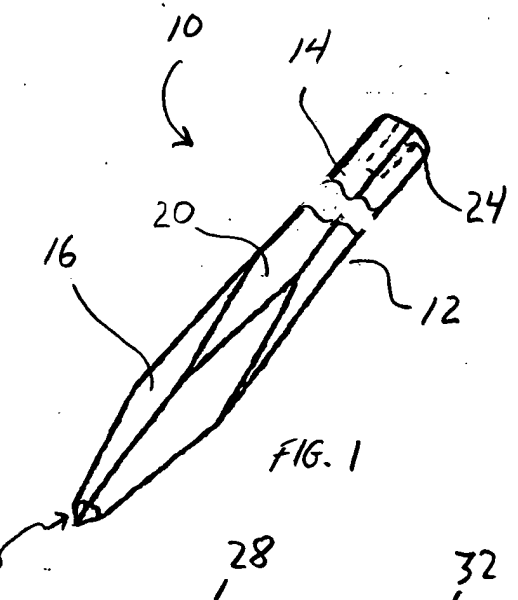


FIG. 1

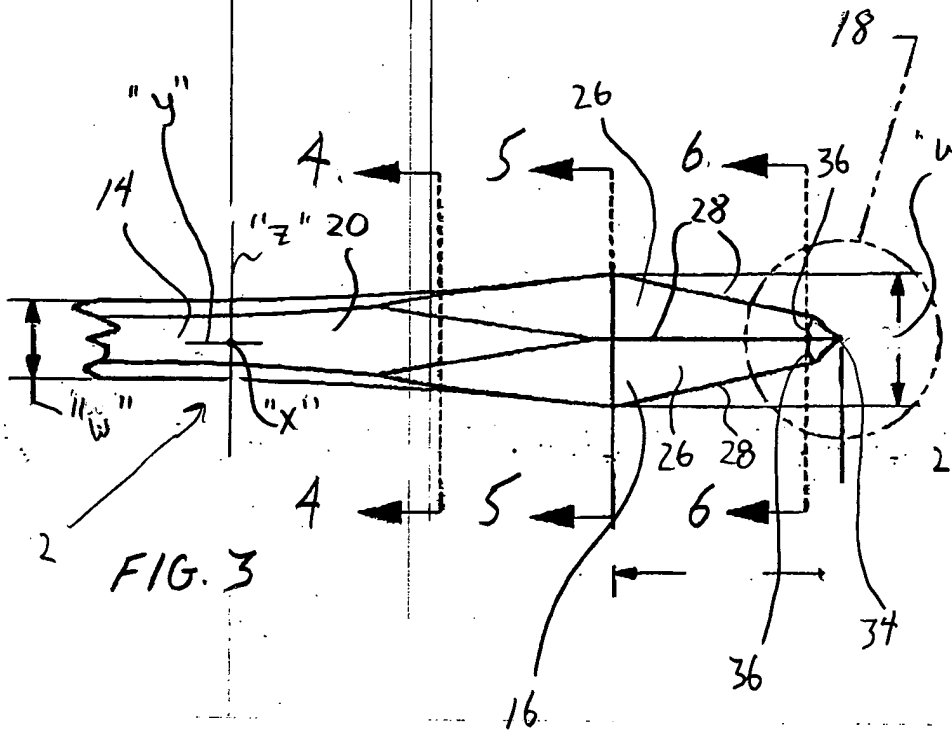


FIG. 3

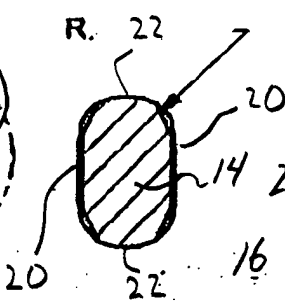


FIG. 4

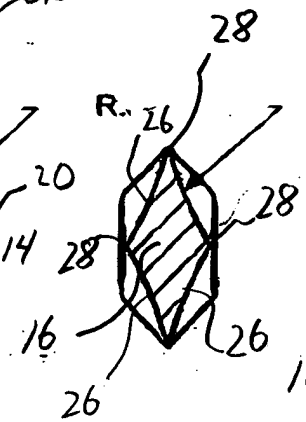


FIG. 5

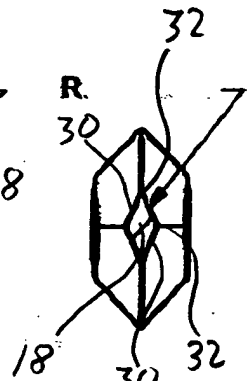


FIG. 6

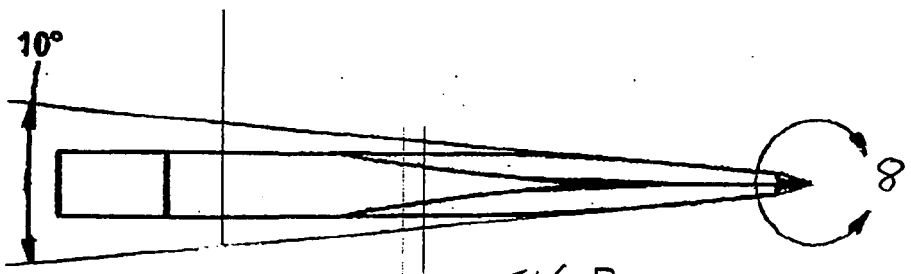


FIG. 7

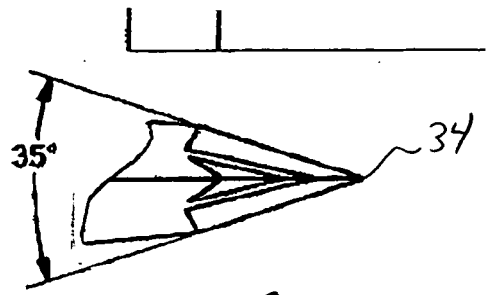
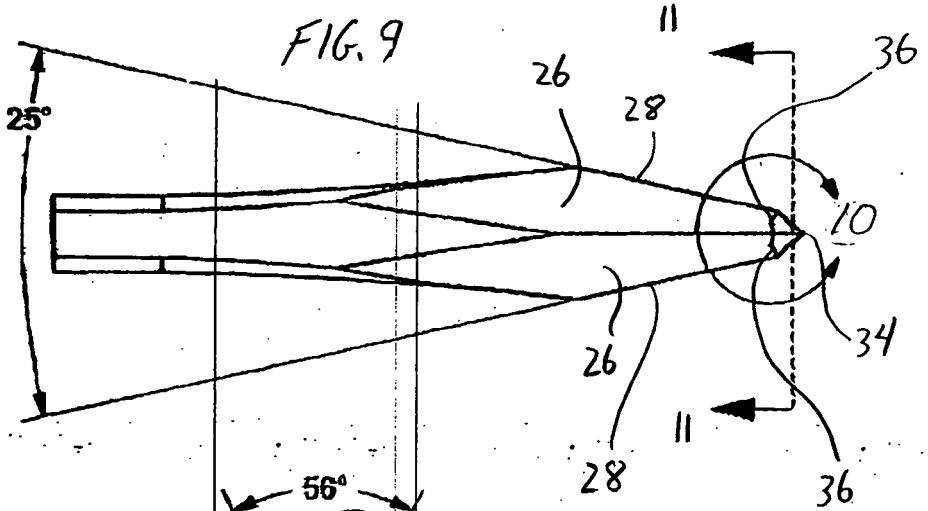


FIG. 8

FIG. 9



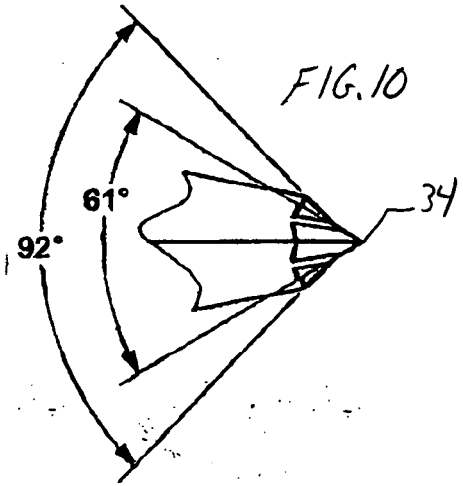


FIG. 10

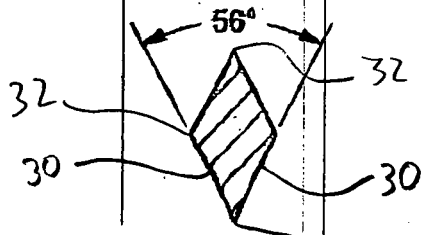


FIG. 11

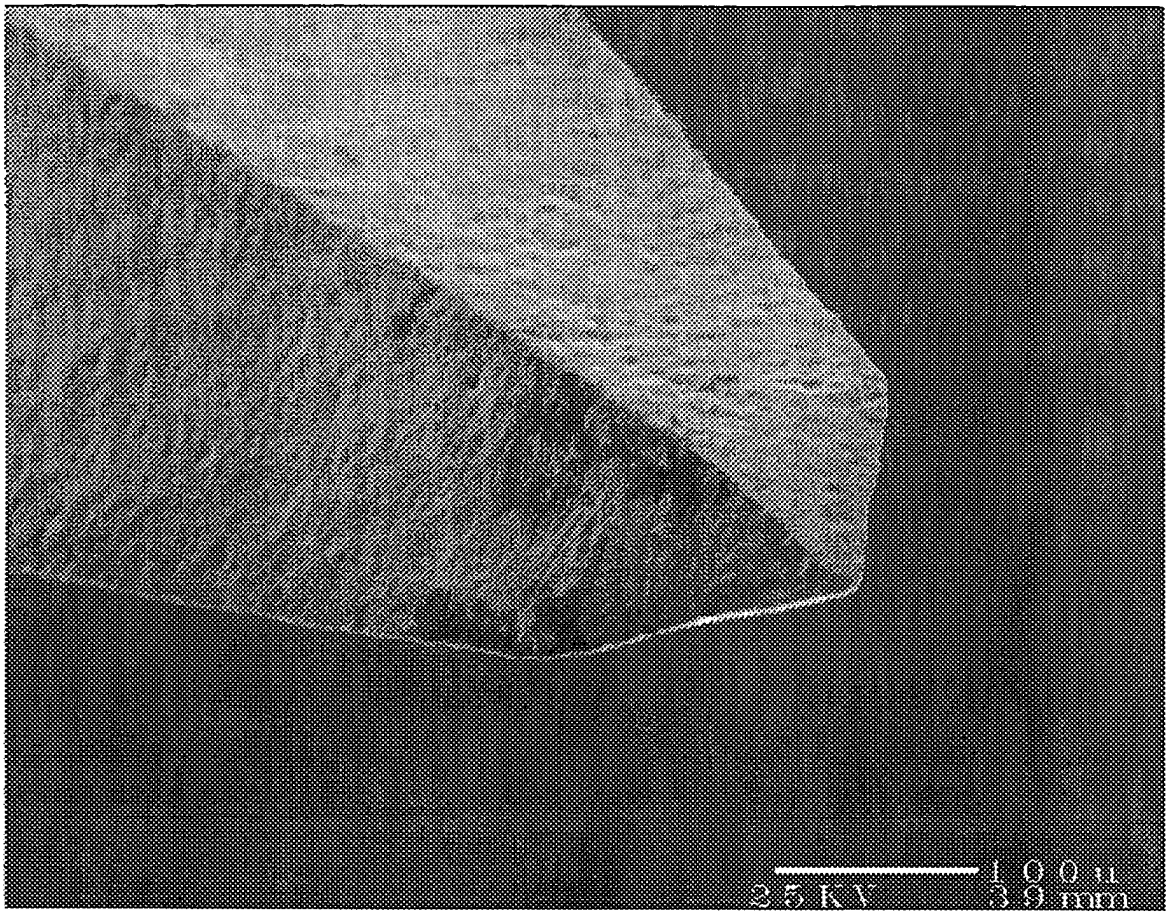


Fig. 12

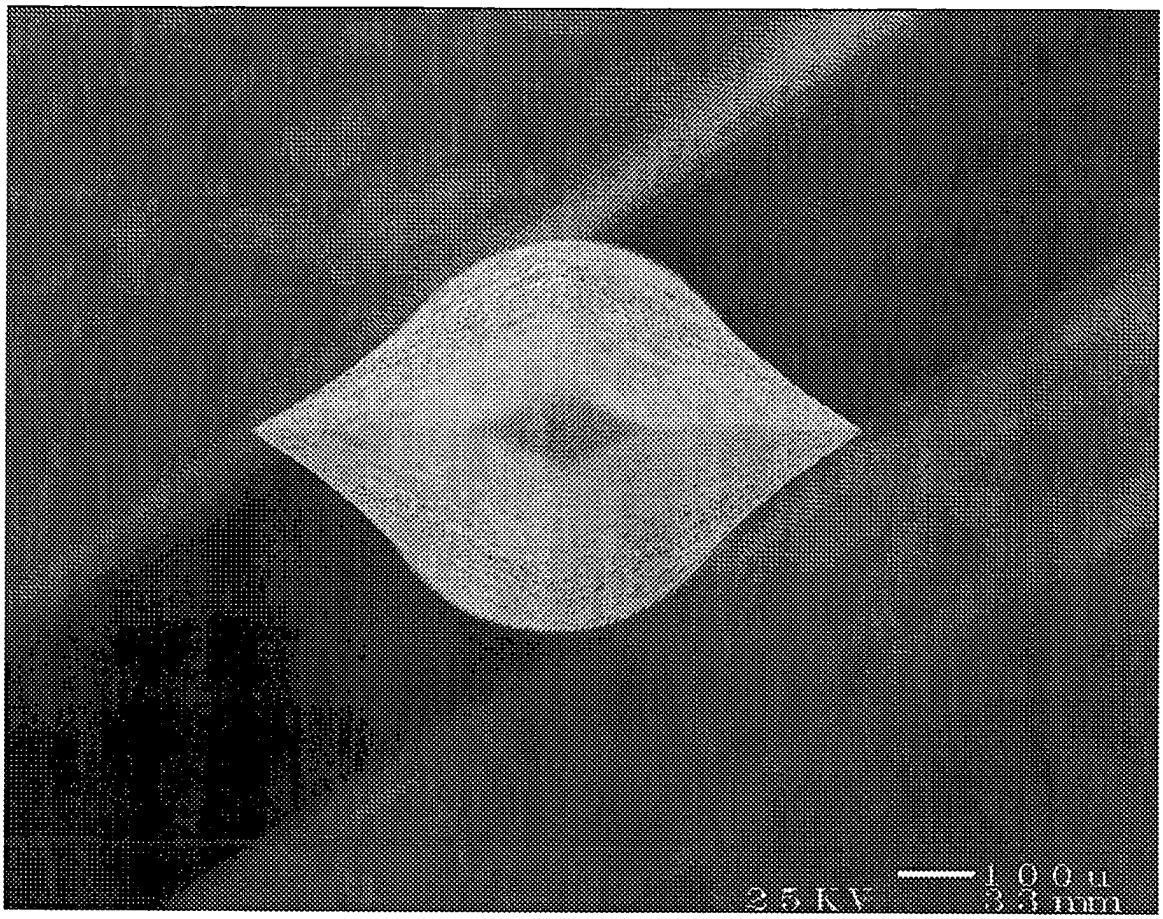


Fig. 13.

Straighten and Cut to Length ~100

Coin Point (ceat flash) ~110

Form Body (flat press) ~120

Form Channel Notch ~130

Curve Needle ~140

In Process QC ~150

Clean Needle ~160

Attach to Strip ~170

Heat Treat ~180

In Process QC ~190

Chemical removal of Flash ~200

Electro Polish ~210

Clean Needle - rinse ~220

In Process QC ~230

Silicone Coating ~240

Remove from Strip ~250

Final QA ~260

Packaging ~270

Overhead ~280

FIG. 14